



**DELTRON**<sup>®</sup>



# Product Information

## DP602

*DP602 - PrimaPRIME*

### PRODUCTS

|                    |                                   |
|--------------------|-----------------------------------|
| Deltron PrimaPRIME | DP602                             |
| Deltron Hardeners  | DH710, DH720, DH730               |
| Deltron Thinners   | DT810, DT820, DT830, DT840, DT860 |
| For flexiblising   | DA210 Flexibliser                 |

### Product Description

Deltron DP602 PrimaPRIME is a G3 shade grey 2K primer-surfacer suitable for a wide range of day-to-day repair work in the refinish bodyshop. Versatile, quick-drying, easy to apply and sand, it offers excellent corrosion resistance, film build, surface levelling and gloss holdout over a wide range of substrates.

PrimaPRIME may be applied directly to sound original paintwork, polyester bodyfillers and suitable adhesion primers. It may be directly overcoated with Deltron Basecoat or Deltron Direct Gloss.

By simple adjustment of the thinning ratio, PrimaPRIME may be applied as a conventional primer surfacer, as a high-build spray filler and as a wet-on-wet surfacer. PrimaPRIME may be air-dried, low-baked or IR cured.

PrimaPRIME may be tinted as necessary with up to 10% by volume of Deltron DG colour.

### PREPARATION OF SUBSTRATE

| <b>Substrate</b>      | <b>Preparation</b>                   |
|-----------------------|--------------------------------------|
| Bare steel            | Must be pre-primed (eg DP612, DP614) |
| Galvanised steel      | Must be pre-primed (eg DP612, DP614) |
| Zintec                | Must be pre-primed (eg DP612, DP614) |
| Aluminium and alloys  | Must be pre-primed (eg DP612)        |
| Electropaint          | P320-P400 (dry)/P400 -600(wet)       |
| Aged painted surfaces | P320-P400 (dry)/P400-600 (wet)       |
| GRP , Fiber-Glass     | P320 (dry)                           |
| Polyester filler      | P120-180 (high-build version)        |
| Featheredge of repair | P240 - 320 (dry)                     |

### Cleaning

Before and after any sanding operation, the substrate must be thoroughly degreased with D845 or D837.

## Application Guide

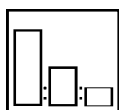
PrimaPRIME can be mixed to create 4 different options according to the requirements of the refinisher:

1. 5:1 with Deltron Hardeners for optimum film build as a Sprayfiller.
2. 5:1:1 with Deltron Hardener and thinner as a primer surfacer.
3. 5:1:1 with DT860 Primer Accelerator Thinner for rapid air-dry and low-bake of small repairs
4. A normal wet-on-wet option activated and thinned at a 5:1:2.5 mix ratio (Do not use DT860 Primer Accelerator Thinner in this mode)

For use as a:                      **Spray Filler Mode**      **Primer Surfacer Mode**      **Wet on Wet Surfacer**

### Mixing Ratio

- RFU mixing available on Paint Manager



|          |             |          |       |          |         |
|----------|-------------|----------|-------|----------|---------|
| DP602    | 5 vol       | DP602    | 5 vol | DP602    | 5 vol   |
| Hardener | 1 vol       | Hardener | 1 vol | Hardener | 1 vol   |
| Thinner  | 0 - 0.5 vol | Thinner  | 1 vol | Thinner  | 2.5 vol |

- DP602 PrimaPRIME **may be tinted** by adding of up to 10% by volume of Deltron DG tinter or mixed DG colour prior to addition of hardener and thinner.
- **Note: Spray filler mode will require 0.5 part thinner if rolling, IR Curing or Baking**

### Hardener and Thinner Selection

#### Temperature

Up to 18°C  
18–25°C  
25–35°C  
Over 35°C

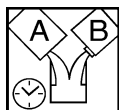
#### Hardener

DH710  
DH720  
DH730  
DH730

#### Thinner

DT810  
DT820  
DT830  
DT840

### Potlife at 20°C

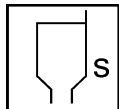


30 mins minimum

1 hour minimum  
(30 mins if using DT860)

1 hour minimum

### Spray Viscosity



40-60 secs DIN at 25°C

20-25 secs DIN at 25°C

15-18 secs DIN at 25°C

## Spraygun Setup



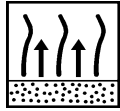
|                       |                     |                     |                     |
|-----------------------|---------------------|---------------------|---------------------|
| Gravity               | 1.8 mm              | 1.6–1.8 mm          | 1.3–1.4 mm          |
| Suction               | 1.8–2 mm            | 1.8 mm              | 1.8 mm              |
| <b>Spray Pressure</b> | 2-3 bar / 30-45 PSI | 2-3 bar / 30-45 PSI | 2-3 bar / 30-45 PSI |

## Number of Coats



|                      |           |           |
|----------------------|-----------|-----------|
| Up to a maximum of 4 | 2–3 coats | 1–2 coats |
|----------------------|-----------|-----------|

## Flash Off at 20°C



|                           |           |           |            |
|---------------------------|-----------|-----------|------------|
| Between coats             | 5–10 mins | 5–10 mins | 5–10 mins  |
| Before wet-on-wet topcoat | N/A       | N/A       | 15 minutes |

|  | Spray Filler Mode | Primer Surfacer Mode | Wet on Wet Surfacer |
|--|-------------------|----------------------|---------------------|
|--|-------------------|----------------------|---------------------|

## Drying Times



|                     |         |                                    |   |
|---------------------|---------|------------------------------------|---|
| Dust-free at 20°C   | 5 mins  | 5 mins                             | 5 mins                                    |
| Through-dry at 20°C | 4 hours | 3 hours<br>(1 hour if using DT860) | Sandable after 2 hours air drying at 20°C |



|                     |   |                                     |     |
|---------------------|---|-------------------------------------|-----|
| Through-dry at 60°C | 30 mins<br><i>Note: Spray filler mode will require 0.5 part thinner if Baking</i> | 30 mins<br>(20 mins if using DT860) | N/A |
|---------------------|---|-------------------------------------|-----|



|                            |  |         |     |
|----------------------------|--|---------|-----|
| Through-dry with IR medium | 20 mins<br><i>Note: Spray filler mode will require 0.5 part thinner if IR Curing</i> | 20 mins | N/A |
|----------------------------|--|---------|-----|

\* Baking time required once metal reaches the quoted temperature. Baking schedule should allow additional time for metal to reach this temperature. - **RFU mixing available on Paint Manager**

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**Technical Data****Total Dry Film Build**

|                |        |       |       |
|----------------|--------|-------|-------|
| <i>Minimum</i> | 130 µm | 40 µm | 15 µm |
| <i>Maximum</i> | 170 µm | 80 µm | 30 µm |

**Theoretical Coverage**

|                             |                             |                              |
|-----------------------------|-----------------------------|------------------------------|
| approx. 2 m <sup>2</sup> /L | approx. 6 m <sup>2</sup> /L | approx. 12 m <sup>2</sup> /L |
|-----------------------------|-----------------------------|------------------------------|

\* Theoretical coverage in m<sup>2</sup>/L ready-to-spray, with a dry film thickness between indicated minimum and maximum values.

**Flash Points**

|  |             |
|--|-------------|
| DH Hardeners, DT Thinners DG tinter and mixed colour | See PPG SDS |
|--|-------------|

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**Sanding**

|                  |                             |
|------------------|-----------------------------|
| <i>Grade dry</i> | P240 followed by P400 - 500 |
| <i>Grade wet</i> | P400 followed by P600 - 800 |

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**Overcoat with**

Any Deltron topcoat.

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## PAINTING OF FLEXIBLE SUBSTRATES - FLEXIBLE substrates are all plastic types except GRP

**Please note:** The positioning of plastic components on motor vehicles, i.e. bumpers, means they are more likely to be subjected to, bumps and knocks from outside sources, such as other motor vehicles, gutters, curbs, brick walls etc. PPG recommends flexibilising all plastics, particularly bumper bars, to improve impact resistance. Additives are also required when applying over a flexible substrate (typically plastics). The additives required and the appropriate volume and weight mix ratios are indicated in the tables below and are also available on paint manager.

In a repair situation PPG recommends that flexibilised 2K primers and polyester filler, be applied over the appropriate PPG plastic primer. (See substrate preparation section in PPG product manual)

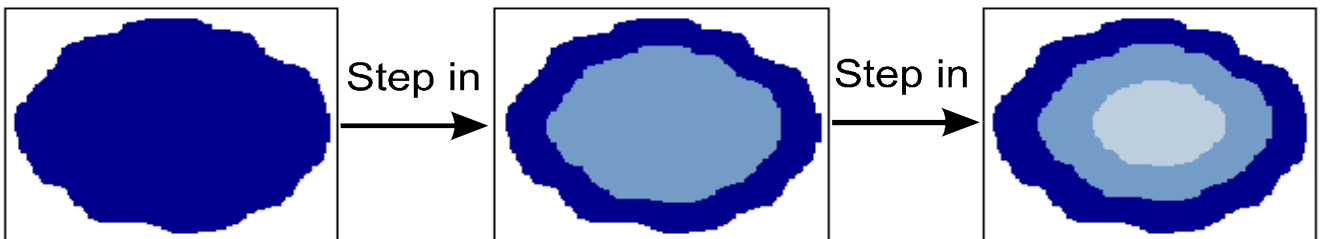
**Note:** Keep primer film build to a minimum on plastic substrates. Apply Maximum 2 coats over D820 Plastic Adhesion Promoter

| Substrate                                       | DP602 PrimaPRIME | DH720 Hardener | DA210 Flexibliser |
|---|------------------|----------------|-------------------|
| FLEXIBLE  | 4 Parts          | 1 Part         | 1Part             |
| <b>RFU Mix ratio available on Paint manager</b> |                  |                |                   |

### Performance Guidelines

When **spot priming** with PrimaPRIME as a Spray Filler / Primer Surfacer, adopt the following procedure:

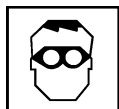
1. Ensure that the surface is thoroughly sanded to the panel edge, breakline or to a distance 15 centimetres beyond the feathered edge area, whichever is the smaller.
2. Apply the first coat to the entire area to be primed then apply subsequent coats inside the previous coat allowing the correct flash-off times between coats. (This avoids building up an edge and trapping dry spray.)



3. Allow to dry as normal, then be careful to thoroughly level the repair edge when sanding. Do not attempt spot repair on original or refinish TPA, lacquer or 1K finishes.
4. DT860 Primer Accelerator Thinner may be used in air dry mode in PrimaPRIME.
5. Do not use DT860 Primer Accelerator Thinner if the primer is to be baked or cured with IR lamps or if higher ambient temperature curing conditions are likely to be experienced.
6. PrimaPRIME and its ancillaries are sensitive to moisture, so all equipment must be perfectly dry. Where humidity is in the range 70–80%, use of DT840 Extra Slow Thinner is recommended. Do not attempt to use PrimaPRIME at humidity levels exceeding 80%.
7. To ensure maximum adhesion and impact resistance, PrimaPRIME must be topcoated within 72 hours of application. After this time it should be sanded and recoated with itself.

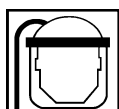
## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.



### Health and Safety

Please refer to Safety Data Sheets for full Health and Safety details.



- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- Do not smoke whilst using this material.
- Do not breathe vapours or overspray. In cases of insufficient ventilation, wear appropriate respiratory equipment.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



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